

Work Order ID 50323

July 14, 2009 12:07:58 PM



Page 1

Item ID: D3278-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacer

Start Date: 7/27/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: MF 09-07-15 Date: 7/27/09

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3278 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

IB 9-7-30

09/07/30



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-7-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 09/07/30



φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50323



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Start Date: 7/27/09

Start Qty: 40.00



Cust Item ID:

Required Date: 7/27/09

Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(P75) =>

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-C'sink as per dwg D32781 12-Deburr

09/08/04

(59)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> 8/08/04

counter

(59)

(41)

150

0.00



Identify as per dwg & Stock Location: 81

Packaging

Memo

0.00

Packaging

59x 9/8/4 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-3 PAR #: N/A Fault Category: Sm Fab NCR: (Yes) No DQA: / Date: 09.08.05
 QA: N/C Closed: / Date: 09.08.17

NCR: <u>50323</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/8/04	#130	one part scrap. Employee touched part on wrong side when counter sink.	<u>/</u> DS1412	Scrap And Destroy no Replace	<u>/</u> 09/08/04	<u>S</u> 09/08/04	<u>/</u> DS1412	<u>S</u> 09/08/04
	Small FAB	EC. Lack of Attention	<u>/</u> DS1412	XXXXXXXXXX	XXXXXXXXXX	XXXXXXXXXX	<u>/</u> DS1412	<u>/</u> DS1412

NOTE: Date & initial all entries

Work Order ID 50323

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Item ID: D3278-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacer

Start Date: 7/27/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date 7-28-09

W 07-08-09

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50323

Parent Item: D3278-3RevC

Parent Item Name: Spacer

Comments:

Start Date: 7/27/09

Required Date: 7/27/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLNS0.125		Purchased	No			110	sf	16.0000	1.4484	60		



Black Delrin Sheet .125

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16

101657

1

104803

11

15607

4

104803 HB 9-7-30

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	50323
Description: Spacer		Part Number:	D3278-3
Inspection Dwg: D3278 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.986	X			
1.98	+/-0.030	1.987	X			
1.480	+/-0.005	1.479	X			
0.250	+/-0.010	.250	*			
1.480	+/-0.005	1.480	*			
0.250	+/-0.010	.250	X			
Ø0.098	+0.005/-0.000	.101	X			
R0.13	+/-0.030	.13	*			
0.125	+/-0.010	.129	*			

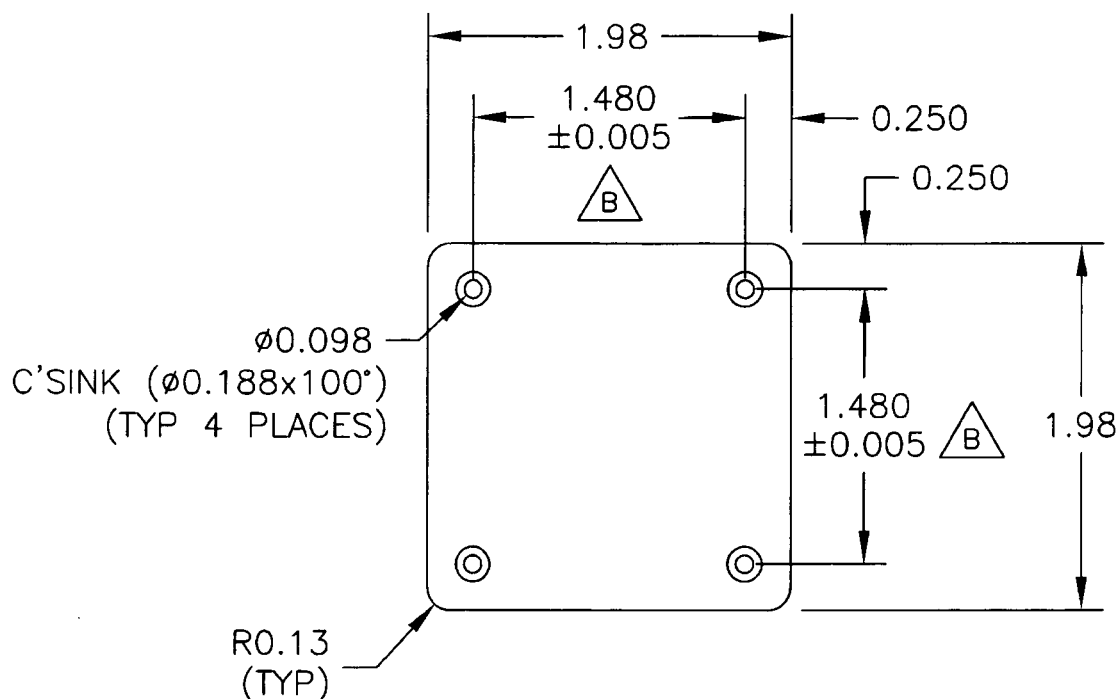
Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	9-7-30	Date:	09/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <div>  </div> </div>



DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50323

mf 09-07-15

D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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